

Work Order ID 71019

Tuesday, June 21, 2011 9:56:07 AM



Page 1

Item ID: D117-762-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 6/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/27/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 6/21/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3492

C

D3582

Rev A

100

0.00



DOCUMENT CONTROL

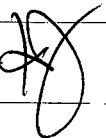
DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D117-762-041 CHG001

N/A 

120

0.00




BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3,
use bending aid DT9632
2- cut fwd end of tube as per dwg1  BBW/07/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Date:

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Run

Start

Stop

Sequence ID/
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Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

Skidtubes

Skidtubes

0.00

Skidtubes

Memo

1-Cut Aft end using DT8185

2-Deburr ends

3-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***

4-Locate DT 8973 & Drill Ground wire hole on top of Tube.

5-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.

6-Drill pilot holes for wearplates using DT8900

7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

8- open ground wear holes to 0.391" as per section B-B

9-Open Aft Cap holes using .209" drill.

10-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.

BB 6/21/11

BE 6/21/11

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Run

Start

Stop

Sequence ID/
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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
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QtyReject
QtyReject
NumberInsp.
Stamp

140



Skidtubes

Skidtubes

Skidtubes

Memo

1-Weld fwd cap D2964 per dwg D3582 and QSI004
A/R AL ROD Batch: *M112860/M115778*
2-Grind flush

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

0.00

0.00

0.00

0.00

*BE 11/07/12**S 11/07/12**S 11/07/12**Q*

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Reference:

Cust Item ID:



Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------------|
| 170  HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | <u>1</u> | | | <u>B</u> 11/07/12 |
| 180  QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | <u>1</u> | <u>0</u> | | <u>BE 11/07/12</u> |

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190 | Skidtubes | 0.00 | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1-Open X-Bolt holes to finish size as per Dwg D3582, all sections | | | | | 1 | | | B 11/07/12 |
| | 2-Counter Sink X-BOLT holes as per Dwg D3582 | | | | | | | | |
| | 3-Deburr and blow out chips from inside of tube, prep. tube for welding. | | | | | | | | |
| | 4-Bond web as per Dwg D3582 & QSI 015 | | | | | 1 | | | B 11/07/12 |
| | A/R 241 Sike Flex Batch: 116945 | | | | | | | | |
| | Exp Date: 12/31/20 | | | | | | | | |
| | 5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B. | | | | | | | | |
| | A/R AL ROD Batch: M112060 | | | | | | | | |
| | 6-Grind welds flush | | | | | | | | |
| 200 | QC10- Inspect visual per QSI004- ground welds | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

200



QC

Quality Control

8 11/07/13

(8)

| W/O: | | WORK ORDER CHANGES | | | | | |
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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

215

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Touch-up alodine as per QSI

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

M117745.
START TIME 9:30
OVEN TEMPERATURE 320°
FINISH TIME 10:00

H D M-L 11/07/13

1 of BL 11-7-14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Required Date: 6/27/2011 Req'd Qty: 1.00



Reference:

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Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 230  QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 1 | 0 | 21 | 6/21/11 |
| 240  HandFinish Hand Finishing | HandFinishing Memo Install Wearplate &Ground Wire inserts as per Dwg D3582. | 0.00 0.00 | | | | 1 | 0 | 21 | 6/21/11 |

| W/O: | | WORK ORDER CHANGES | | | | | |
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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

250


HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex Batch: M117516
Exp Date: 15/01

3-Install Wearplates as per Dwg D3582,

Note: Install Bolt and washer on Ground Wire inserts on top of tube see
section D-D of dwg D3582

*****Do not install bolts where indicated on Dwg(Note #6)*****

A/R 241 Sika Flex Batch: M117516
Exp Date: 15/01

4-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M114189

5- Wing Walk as per Dwg D3582 and QSI 005 4.4

M117863

260


QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S w a l k

1 0 20 16714(70) _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



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|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 270 | Packaging | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | Identify and pack for shipping as per PPP D117-762-041 Location: _____ PPP Rev: _____ | | | | | | | | |
| 280 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

PPP 71022

11/7/15

11/7/18

cmf
11-07-15

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**Required Date:** 6/27/2011

Required Qty: 1.00

Comments: IPP Rev:A 07.06.11 New Issue EC
IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|----------------|--------|
| D3492-11  Plug | | Manufactured | No | | | 250 | Each | 6.0000 | 2 | 2 | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | FP | | | 6 | | | | | | |
| | | | | | 70410 | | 6 | | | | | | |
| D3492-13  Plug | | Manufactured | No | | | 250 | Each | 27.0000 | 6 | 6 | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | FP-B | | | 27 | | | | | | |
| | | | | | 46693 | | 27 | | | | | | |
| D3492-9  Plug | | Manufactured | No | | | 250 | Each | 45.0000 | 2 | 2 | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | FP-A | | | 45 | | | | | | |
| | | | | | 46694 | | 45 | | | | | | |
| D2962-150  3.540 Outer Tube, Extrut | | Manufactured | No | | | | Each | 82.0000 | | 1 | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | HALL | | | 82 | | | | | | |
| | | | | | 28672 | | 9 | | | | | | |
| | | | | | 59934 | | 73 | | | | | | |

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Picklist Print

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Work Order ID: 71019

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 6/27/2011

Start Qty: 1.00

Required Qty: 1.00

D2964 Manufactured No

140 Each

22.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG002

22

14101

8

64654

14

D2971 Manufactured No

190 Each

17.0000

1

1



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG001

17

44445

17

D3584-1 Manufactured No

190 Each

0.0000

1

1



Web

D2973

Manufactured No

190 Each

139.0000

2

2



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG002

139

14636

139

D3662-3 Manufactured No

190 Each

17.0000

1

1



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG001

17

44456

17

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Shop Packet Print

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 9:56:14 AM

Page 3

Work Order ID: 71019

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

D3662-1 Manufactured No
Crossbolt Spacer

ALS4-1032-130 Purchased No
Insert

ALS4-428-165 Purchased No
Inserts

D2965 Manufactured No
Cap, 105 Skidtube

Location
LG001
64451

Location
ST281
117331
ST282
1470
1470
117717

Location
FP
117769
FP-B
114172

Location
FP006
52057

190 Each 7.0000 3 3

Loc Qty Loc Code
7
7

240 Each 1,478.000 36 36

Loc Qty Loc Code
8
8
1470
1470

240 Each 529.0000 2 2

Loc Qty Loc Code
486
486
43
43

250 Each 28.0000 1 1

Loc Qty Loc Code
28
28

Start Date: 6/21/2011

Required Date: 6/27/2011

Start Qty: 1.00

Required Qty: 1.00



BB 11/07/13
B 64451 x1
B 71799 x2



11/07/14



11/07/14



11/07/14

Tuesday, June 21, 2011 9:56:15 AM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 9:56:15 AM

Page 4

Work Order ID: 71019

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 6/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3508-3 Manufactured No

250 Each

6.0000

1

1



Wearplate

Location

Loc Qty

Loc Code

FP021

6

1371210

38527

1

67489

5

D3508-9 Manufactured No

250 Each

10.0000

1

1



Wearplate

Location

Loc Qty

Loc Code

FP021

10

70307

10

D3558-3 Manufactured No

250 Each

9.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP014

9

67486

9

D3558-9 Manufactured No

250 Each

6.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP014

6

55469

6

D3558-11 Manufactured No

250 Each

11.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP014

11

70312

11

Tuesday, June 21, 2011 9:56:15 AM

Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 9:56:15 AM

Page 5

Work Order ID: 71019

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 6/27/2011

Start Qty: 1.00

Required Qty: 1.00

D3558-13 Manufactured No

250

Each

25.0000

1

1



Gasket

Location

FP014

Loc Qty

25

Loc Code

59558

25

xl

D3508-11 Manufactured No

250

Each

9.0000

1

1



Wearplate

Location

FP016

Loc Qty

9

Loc Code

69941

9

xl

D3508-13 Manufactured No

250

Each

3.0000

1

1



Wearplate

Location

FP016

Loc Qty

3

Loc Code

65191

3

xl

AN960JD10L NAS1149D0332L Purchased No

250

Each

0.0000

2

2



Washer

1117087

(x2) xl 1107114

Tuesday, June 21, 2011 9:56:15 AM

Shop Packet Print

Page 5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 9:56:15 AM

Page 6

Work Order ID: 71019

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 6/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A
BOLT
Purchased No

250 Each 2,175.000 28 28

Location

Loc Qty

Loc Code

ST350

2175

117094

181

117313

2

117688

800

117795

500

117872

192

118012

500

AN3C5A
Bolt
Purchased No

250 Each 1,413.000 2 2

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1406

116419

28

116549

54

117343

500

117508

24

117764

300

117872

500

AN960JD416L
Washer
NAS1149D0416J Purchased No

250 Each 29.0000 2 2

Location

Loc Qty

Loc Code

FP-B

29

110153

29

2116513

x2

Tuesday, June 21, 2011 9:56:16 AM

Shop Packet Print

Page 6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 9:56:16 AM

Page 7

Work Order ID: 71019

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 6/27/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

250 Each 0.0000 28 28



washer

1118306



(x28) 11/07/14

AN4-4A Purchased No

250 Each 96.0000 2 2



11/07/14

Bolt

Location

Loc Qty

Loc Code

FP-B

44

114615

44

ST356

52

x2

114615

52

NAS1611-012 Purchased No

250 Each 50.0000 6 6



11/07/14

O-RING

Location

Loc Qty

Loc Code

FP-A

50

113845

50

x6

NAS1611-015 Purchased No

250 Each 85.0000 2 2



11/07/14

O-RING

Location

Loc Qty

Loc Code

FP-A

85

115101

85

1116081

x2

Tuesday, June 21, 2011 9:56:16 AM

Shop Packet Print

Page 7

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 9:56:16 AM

Page 8

Work Order ID: 71019

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 6/27/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-016

Purchased

No

250

Each

103.0000

2

2



O-RING



Handwritten: 1107114

Location

Loc Qty

Loc Code

FP-A

103

107178

1

112492

58

113524

44

Handwritten: x2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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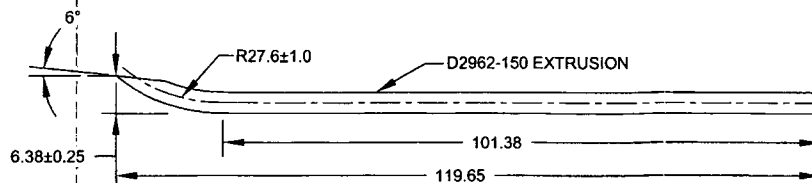
NOTE: Date & initial all entries

PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

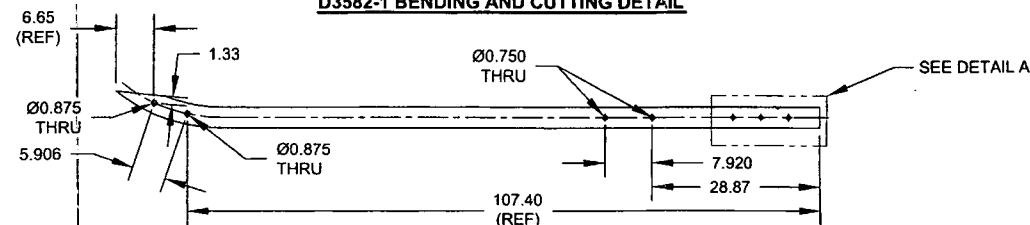
| Qty | Part Number | Description |
|-----|---------------|-------------------|
| X | D3582-041 | SKIDTUBE ASSEMBLY |
| 1 | D2962-150 | EXTRUSION |
| 1 | D2964 | CAP |
| 1 | D2965 | CAP |
| 1 | D2971 | CROSS BOLT SPACER |
| 2 | D2973 | CROSS BOLT SPACER |
| 2 | D3492-049 | PLUG ASSEMBLY |
| 2 | D3492-051 | PLUG ASSEMBLY |
| 6 | D3492-053 | PLUG ASSEMBLY |
| 1 | D3508-3 | WEARPLATE |
| 1 | D3508-9 | WEARPLATE |
| 1 | D3508-11 | WEARPLATE |
| 1 | D3508-13 | WEARPLATE |
| 1 | D3558-3 | GASKET |
| 1 | D3558-9 | GASKET |
| 1 | D3558-11 | GASKET |
| 1 | D3558-13 | GASKET |
| 1 | D3584-1 | WEB |
| 3 | D3662-1 | CROSS BOLT SPACER |
| 1 | D3662-3 | CROSS BOLT SPACER |
| 36 | AELS-1032-130 | INSERT |
| 2 | ALS7-428-165 | INSERT |
| 28 | AN3C4A | BOLT |
| 2 | AN3-5A | BOLT |
| 2 | AN4-4A | BOLT |
| 28 | AN960C10L | WASHER |
| 2 | AN960JD10L | WASHER |
| 2 | AN960JD416L | WASHER |

GENERAL NOTES:

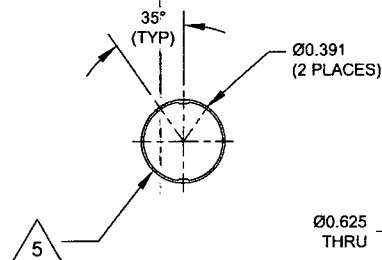
- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) WELDING TO BE DONE PER DART QSI 004
- 4) INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-2411-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 5) USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-2411-291.
- 6) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- 7) FINISH:
 - A) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 - B) POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - C) ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



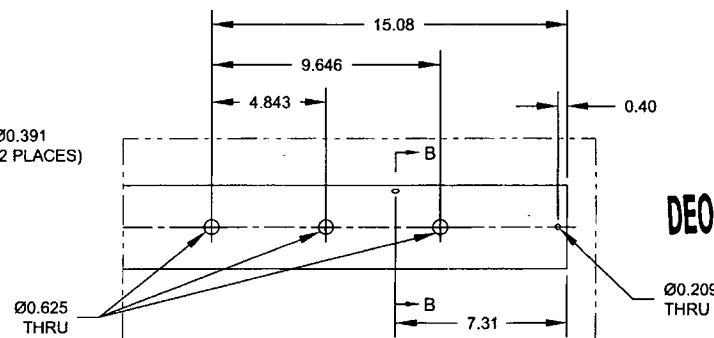
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5



DETAIL A
SCALE 1:5

DEO ATTACHED

RELEASED
07.11.2007

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
710219

| A | NEW ISSUE | PH | 07.06.08 |
|------------|-------------|----|----------|
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PH | | |
| DRAWN | PH | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 07.06.08 | | |

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3582
REV. A
SHEET 1 OF 2

TITLE BK 117 SKIDTUBE ASSEMBLY
SCALE 1:20

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PH 11-06-21

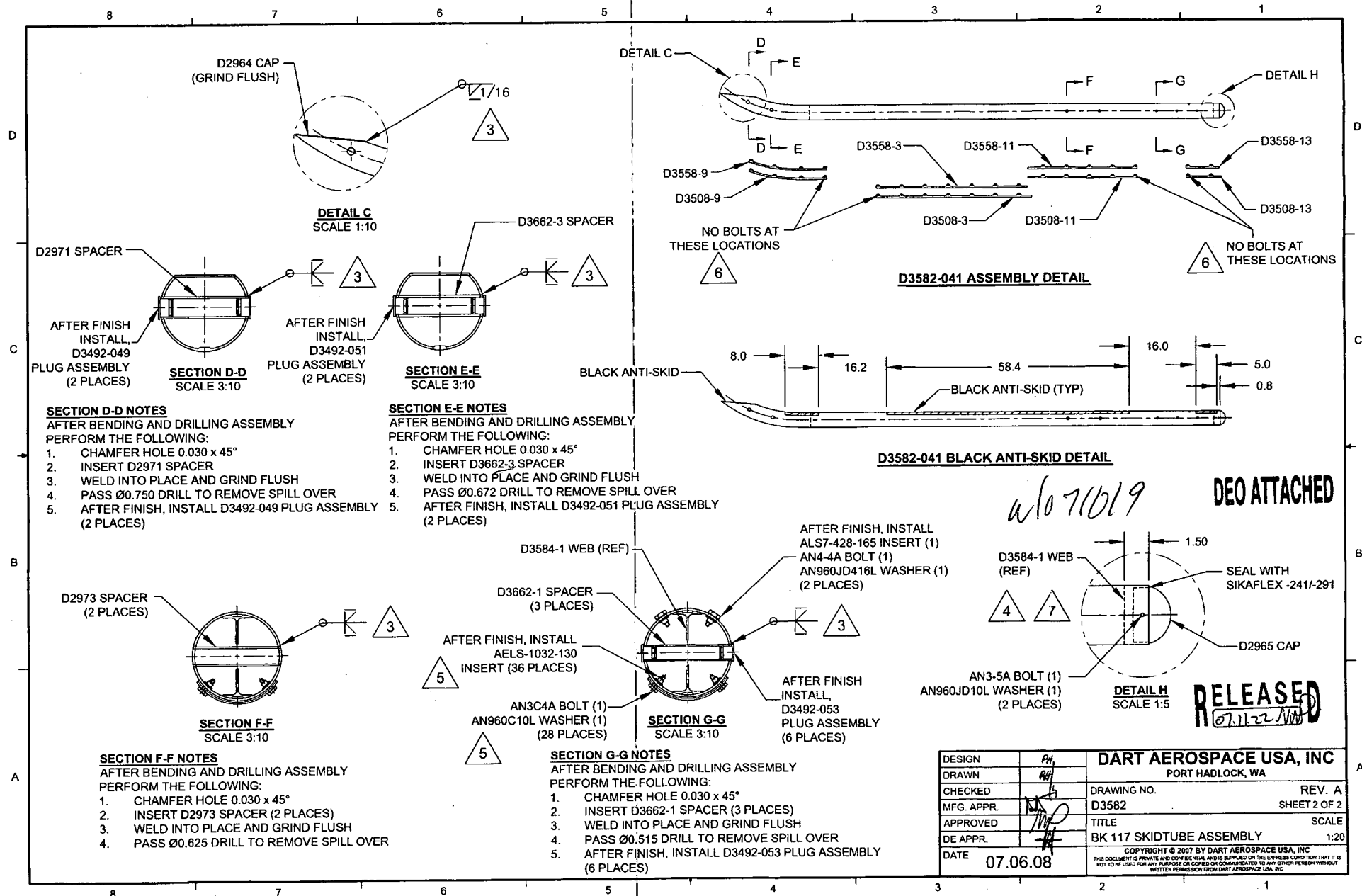
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



| W/O: | | WORK ORDER CHANGES | | | | | |
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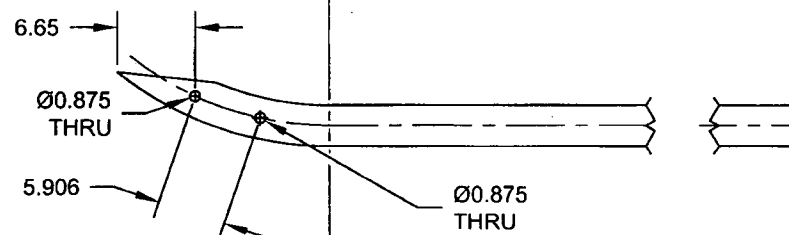
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

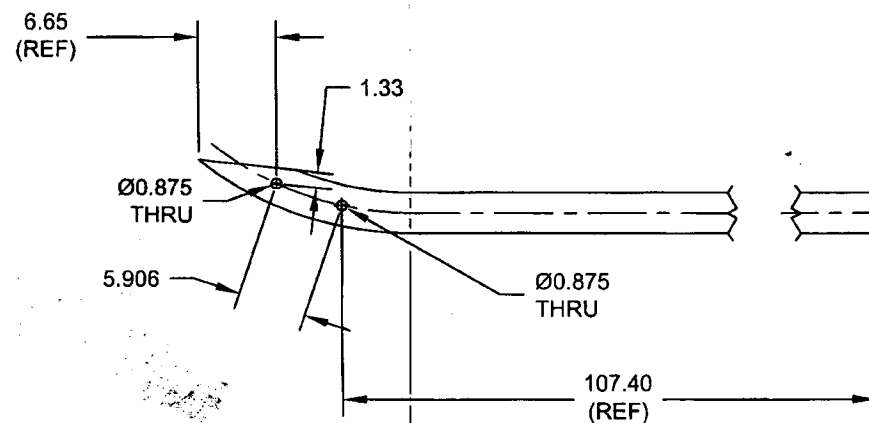
| | | | | | | | |
|----------------------|-----------------------------------|----------------------------------|--|--|--------------------------------|---------------------------|--------------|
| DRAWING NO. D3582 | TITLE BK 117 SKIDTUBE ASSEMBLY | REV. A | DART AEROSPACE USA, INC ENGINEERING ORDER | | D.E.O. NO. D3582-A-1 | SHEET NO. SHEET 1 OF 1 | SCALE NTS |
| DRAWN <i>PH</i> | CHECKED <i>[Signature]</i> | MFG. APPR. <i>[Signature]</i> | APPROVED <i>[Signature]</i> | | DE APPR. <i>[Signature]</i> | | |
| DATE 09.04.06 | DATE 04.04.06 | DATE 09.04.06 | DATE 19/04/06 | | DATE 09.04.06 | | |

FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR:
UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



u/b 71019

RELEASED
09/04/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

NO. 245

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 65186
Part number: D117-762-041
Description: 117 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Sal Lunn Date of Test Coupon 11-01-31

Welder Barclay Elliott Date of Test Coupon 11-01-31

The above named individual is qualified in accordance with AWS D17.1.2001 to weld